

**Work Order ID 63928**

Page 1

Friday, November 19, 2010 10:02:13 AM

Item ID: D3622-1

Accept



Setup Start



Revision ID:

Item Name: Ball Stud

Stop



Start Date: 11/19/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 11/26/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10/14/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**
**Tool ID**
**Tool #**
**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

Draw Nbr	Revision Nbr
D3622	Rev B

100



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

**Memo**

0.00

 1-TURN AS PER FOLIO FA686 & DWG D3622,  
 FOLIO REV: R  
 DWG REV: R  
 2-DEBURR AS REQUIRED


  
 10/12/06

20 6

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

**Memo**

0.00

  
 10/12/06

20 6

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

**Memo**

0.00

 0.00
 
  
 10/12/06

20 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 63928**

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: T70

0.00

10/12/10

SF 200

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/07 JJ

10/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Friday, November 19, 2010 10:02:17 AM

Work Order ID: 63928



Parent Item: D3622-1



Parent Item Name: Ball Stud

Start Date: 11/19/2010

Required Date: 11/15/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500 303 HEX BAR .500		Purchased		No		100	f	121.3480	0.108	2.273684		SA 10/12/06	

Location	Loc Qty	Loc Code
MAT037	121.348	
109778	99.548	
109846	21.8	

2.2 ft

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<i>43928</i>
<b>Description:</b> Ball Stud	<b>Part Number:</b>	D3622-1
<b>Inspection Dwg:</b> D3622 <b>Rev:</b> B		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>25</u>	Audited by:	<u>OK</u>	Prototype Approval:	N/A
Date:	10/12/06	Date:	10/12/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.v2.02	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

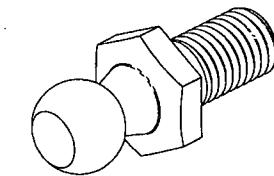
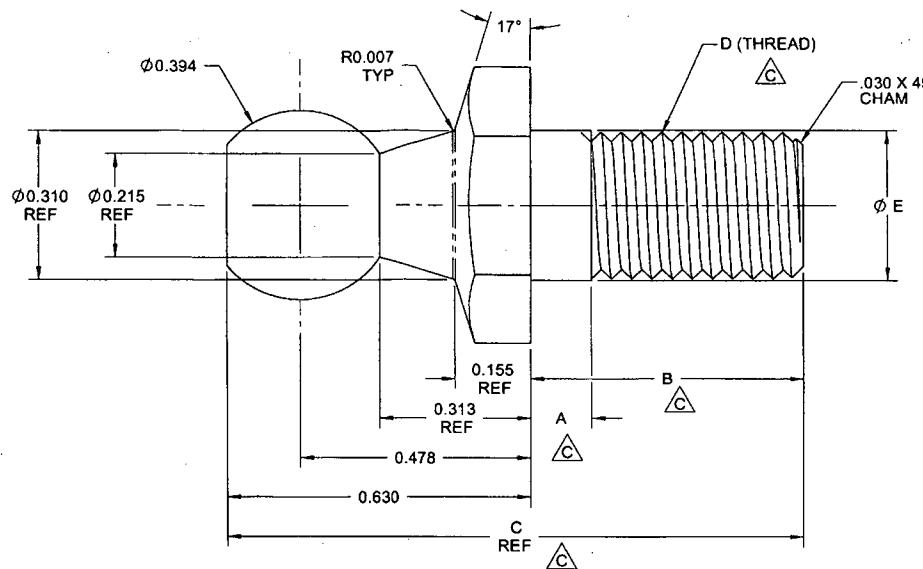
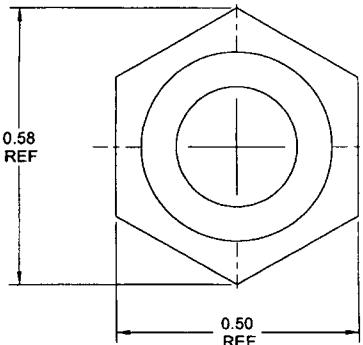
5

4

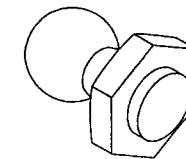
3

2

1



**D3622-1 BALL STUD SHOWN**



**D3622-11 BALL STUD SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E MIN MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840 0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270 0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053 0.3125

**D3622-X BALL STUD**

NOTES:  
 1) MATERIAL: AISI 303 HEX BAR  
     REF DART SPEC M303H0.500  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044  
 7) WEIGHT: SEE D3622-X TABLE

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 13928

*Bl 10-11-19*

C	SHEET 1: ADD-5,-7,-9,-11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED		JPH	10.07.20
B	ADD-3 (SHEET 2)		HS	09.09.18
A	NEW ISSUE		MB	07.04.13
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3622	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		BALL STUD	NTS	
DATE	10.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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